

Date: Tuesday, 29/01/2008 9:14:55 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER			
Job Number	: 37034						
Estimate Number	: 11178						
P.O. Number	:			Part Number	: D32931		
This Issue	: 29/01/2008	S.O. No. :		Drawing Number	: D3293 REV A		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /	Type :	SMALL /MED FAB	Drawing Revision	: A		
Previous Run	: 36634			Material	:		
Written By	:			Due Date	: 15/02/2008		
Checked & Approved By	:			Qty:	20	Um: Each	
Comment	: Est:A 04.08.24 New issue KJ/JLM Est Rev:B Now on Waterjet 06-11-02 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S080	2024-T3 .080 sheet	
		35	
		Comment: Qty.: 1.9177 sf(s)/Unit Total : 38.3544 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.080" thick (M2024T3S.080) Identify for D3293-1 Batch: 105411 1B 8-1-29 18481 X 2 = 4. <sup>\$60</sup>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3293 Dwg Rev: A 1B 8-1-29 Prog Rev: A	
		2-Deburr if necessary 1B 8-1-29	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		1B 8-1-29	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		1.08/01/2008 (+20)	
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/06/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 29/01/2008 9:14:55 AM  
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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

*n/a Done at step #2.2*

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*a.m 08.01.31*

(20)

8.0 POWDER COATING

POWDER COATING



*M1100700*

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*90*

*08.01.31 X20*

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M-1 08/01/31*

(20)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *211*

*8/1/1 54 (20)*

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/02/04*

Job Completion



*in 2008/12/04 (20)*

*W*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD	
<i>[Signature]</i>		<i>[Signature]</i>		HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. A
		<i>[Signature]</i>		D 3293	SHEET 1 OF 1
DATE		TITLE		SCALE	
04.06.28		DOUBLER		1:3	
A	04.06.28	NEW ISSUE			

D3293-1 DOUBLER

MAKE PER DRAWING FILE "D3293-A1.DWG"

CHECK PER TEMPLATE D3293-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BL

DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 012 UNLESS OTHERWISE NOTED

A technical drawing showing a circle with two concentric features. The outer feature is a semi-circle with a radius of R0.354 (TYP), indicated by a dimension line and arrow. The inner feature is a smaller circle with a radius of R0.312, also indicated by a dimension line and arrow. A horizontal line passes through the center of the circles, with a dimension of 0.312 placed below it. Arrows point from the dimension lines to the respective radii.

DETAIL A  
SCALE 2:3

PLEASE  
DO NOT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37034
Description: Double	Part Number:	D3293-1
Inspection Dwg: D3293-1 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	HB	Audited by:	J	Prototype Approval:	N
Date:	8-1-29	Date:	05/14/20	Date:	17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	